

# Work Order ID 50753

July 21, 2009 1:35:24 PM

Page 1

Item ID: D3405-043

Accept

Revision ID: B

Item Name: Lug Assembly

Start Date: 07/22/2009 Start Qty: 4.00

Required Date: 07/31/2009 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 09-07-07 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3405

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3405 11Dwg Rev: B 11Prog Rev: B 12-  
Deburr if necessary

IB 9-7-07

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 9-7-07

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

⇒ S 09/07/07 (18) f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 50753

July 21, 2009 1:35:24 PM



Page 2

Item ID: D3405-043

Accept



Setup Start



Revision ID: B

Stop



Item Name: Lug Assembly

Start Date: 07/22/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 07/31/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



NC BRAKE

Brake NC

Memo

0.00

8/09/08/11

8

0

Brake NC

Deburr Form using DT8204 as per Dwg D3405

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

2) 8/09/08/11

28

f

Quality Control

150

0.00



Large Fab

Large Fab

Memo

0.00

EL 9-8-24 (K8)

Large Fab

Weld as per Dwg D3405 Identify as D3405-043

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 50753

July 21, 2009 1:35:24 PM



Page 3

Item ID: D3405-043

Accept



Setup Start



Revision ID: B

Stop



Item Name: Lug Assembly

Start Date: 07/22/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 07/31/2009 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

CPC 09-08-24



QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

=> S 09/08/24



QC

Memo

0.00

Quality Control

(ES) 0

180

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M112260



Powdercoat

Memo

0.00

=> 2V 09/08/25

x8 0

Powder Coating

START TIME: 7:00AM OVEN TEMPERATURE:

7:30AM FINISH TIME:

4009

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 50753

July 21, 2009 1:35:24 PM

Page 4

Item ID: D3405-043

Accept

Revision ID: B

Item Name: Lug Assembly

Start Date: 07/22/2009 Start Qty: 4.00

Required Date: 07/31/2009 Req'd Qty: 4.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

190

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

BR 09-08-25

(8)

200

Identify as per dwg & Stock Location: 474

0.00



Packaging

Memo

0.00

Packaging

9/8/26 (8) SP

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/26

PL 09-F-26 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

July 21, 2009 1:35:24 PM

Page 1

Work Order ID: 50753

Parent Item: D3405-043RevB

Parent Item Name: Lug Assembly


Comments:

Start Date: 07/22/2009

Required Date: 07/31/2009

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3404-1RevC		Manufactured	No			100	Each	8.0000	4.0000			
<div>  </div>												
GHW Lug												

M304S11GA



304/316 0.125 Sheet

Purchased

No

Warehouse  
Location  
 Main Warehouse  
 ST

8

8

150

sf

108.5733

0.6484

Warehouse  
Location  
 Main Warehouse  
 MAT  
 111018

108.5732632

108.573263

~~111018~~

111018 B 9-7-07

D3404-1

B60252 x3  
 B50471 x5

EL 9-8-04.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

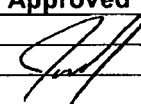
<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	50753
<b>Description:</b> GHW Bracket		<b>Part Number:</b>	D3405-3
<b>Inspection Dwg:</b> D3405 <b>Rev:</b> B		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

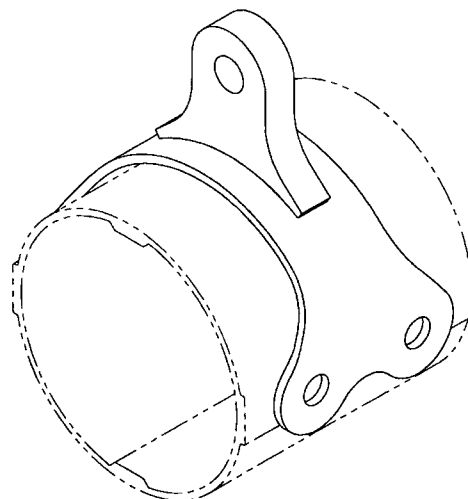
☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.438	+0.006/-0.001	.440	X			
1.50	+/-0.030	1.513	X			
1.750	+/-0.010	1.750	X			
R0.63	+/-0.030	.63	X			
3.00	+/-0.030	3.003	X			
8.00	+/-0.030	7.997	X			
6.751	+/-0.005	6.752	X			

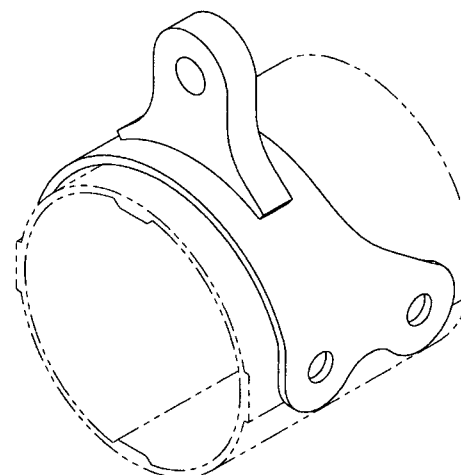
<b>Measured by:</b> B	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 9-7-07	<b>Date:</b> 09/07/07	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.01	New Issue      P/O D3405-043	KJ/JLM	
B	09.05.04	Dimensions update per Dwg Rev. B	KJ/DD	

ITEM No.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D3405-041	LUG ASSEMBLY
2		X	D3405-043	LUG ASSEMBLY
11	1	1	D3404-1	GHW LUG
12	1		D3405-1	GHW BRACKET
13		1	D3405-3	GHW BRACKET



**D3405-041 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)



**D3405-043 LUG ASSEMBLY**  
(SKID TUBE SECTION SHOWN  
FOR REF ONLY)

50753

**RELEASED**  
06/12/18

**NOTES:**

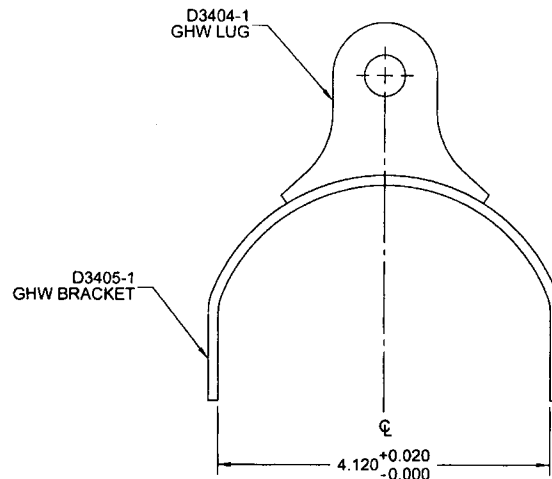
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3405-041" USING FINE POINT PERMANENT INK MARKER  
: IDENTIFY WITH DART P/N "D3405-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -041, 0.85 lbs  
-043, 0.87 lbs

B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERNS FOR -1 & -3 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). SHEETS 3 & 4 ZONE A6 4.120 DIM WAS 4.100.	AJS	08.09.19
A	NEW ISSUE	PH	05.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.19		

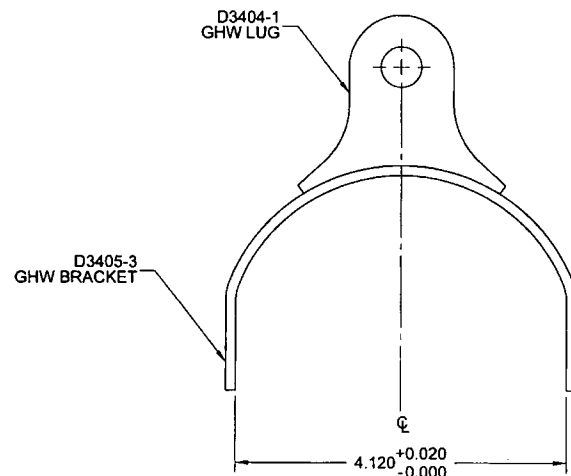
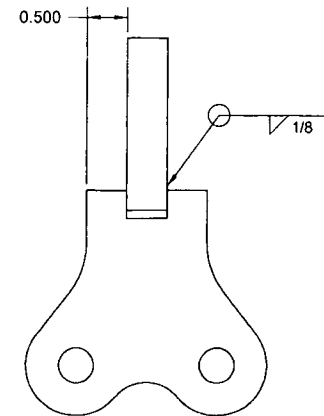
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3405** REV. B  
SHEET 1 OF 4  
TITLE **GHW LUG ASSEMBLY** SCALE NTS

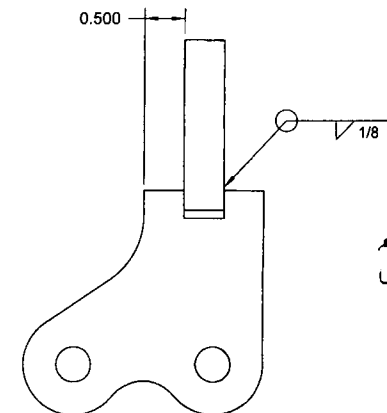
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**D3405-041 LUG ASSEMBLY**



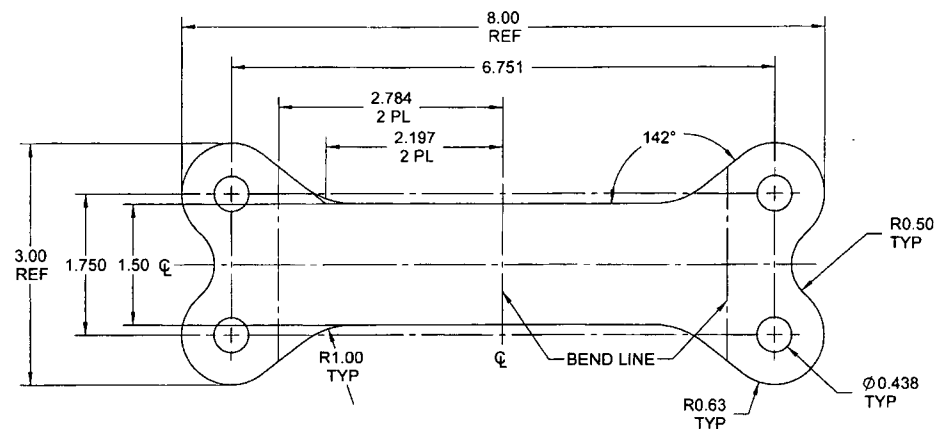
**D3405-043 LUG ASSEMBLY**



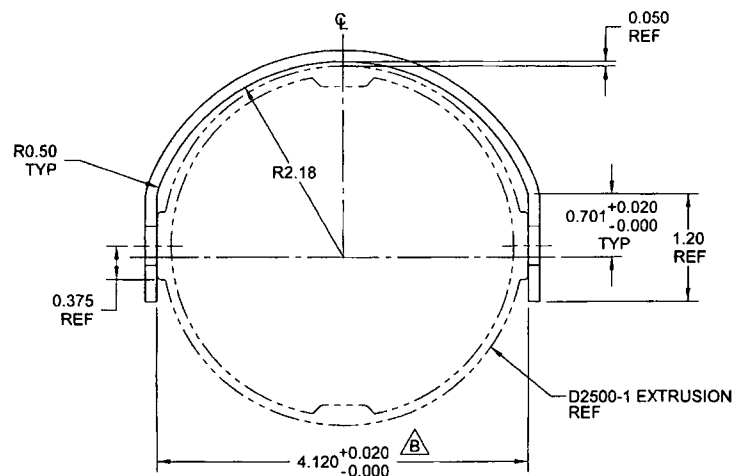
50753

RELEASED  
06/12/18 JH

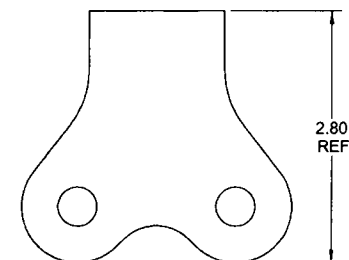
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D3405	REV. B
MFG. APPR.		TITLE	SHEET 2 OF 4
APPROVED		GHW LUG ASSEMBLY	SCALE
DE APPR.			NTS
DATE	08.09.19	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



**D3405-1F GHW BRACKET FLAT PATTERN**



**D3405-1 GHW BRACKET**  
(MAKE FROM D3405-1F)



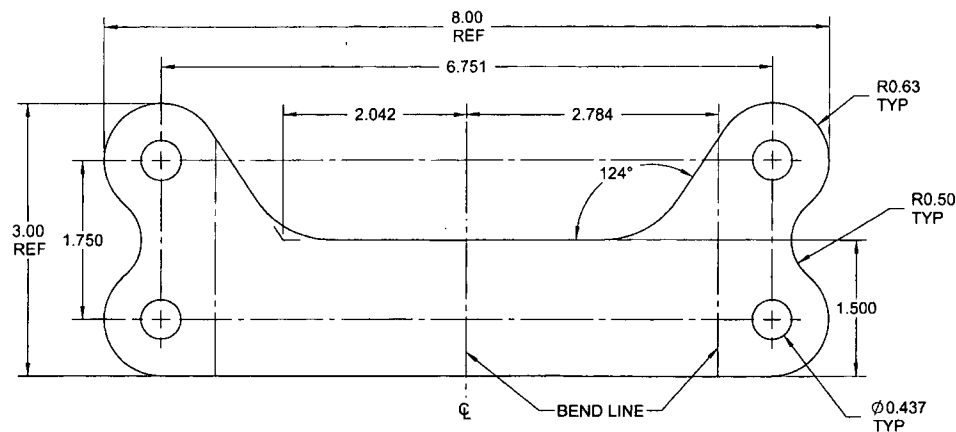
SIDE VIEW FOR REF ONLY

**NOTES:**

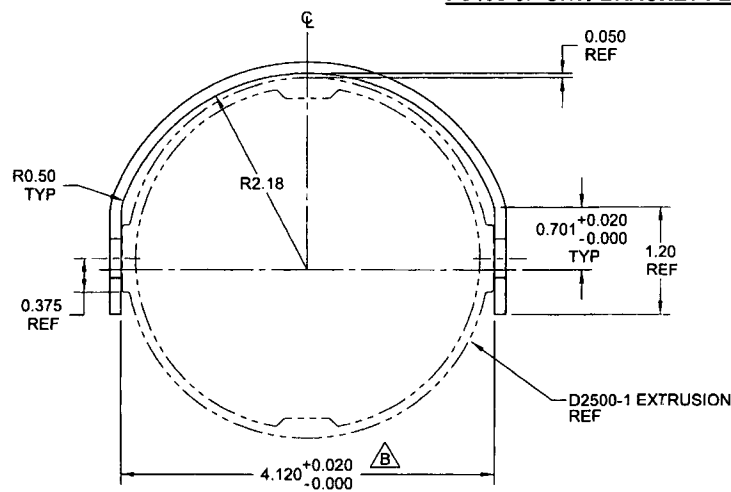
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. <b>D3405</b>	REV. B SHEET 3 OF 4
MFG. APPR.		TITLE <b>GHW LUG ASSEMBLY</b>	SCALE NTS
APPROVED		COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.			
DATE	08.09.19		

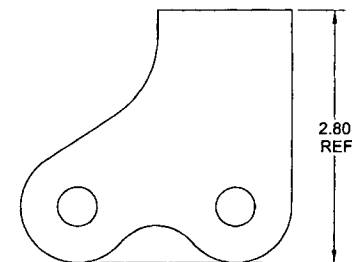
50753  
**RELEASED**  
08/12/18



**D3405-3F GHW BRACKET FLAT PATTERN**





**D3405-3 GHW BRACKET**  
(MAKE FROM D3405-3F)



SIDE VIEW FOR REF ONLY

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524  
REF. DART SPEC. M304S11GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

DESIGN	PH	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3405	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG ASSEMBLY	NTS
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50753  
**RELEASED**  
08/12/18 NV